



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D6103-003
Job Sheet 174248



- 5054534-

Part No: D6103-003

Job Qty: 15 ea

Part Name: Round Billet, Aluminum



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/13/18

Job Tracking No:

Due Date: 3/23/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DA Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	15 pcs		3/23/18	0.00	0.00	Purchasing		1 MAR 23 2018
110	Packaging	15 pcs		3/23/18	0.00	0.00	Packaging2		9-89 BAS 11 MAR 23 2018
120	QC	15 pcs		3/23/18	0.00	0.00	QC6		11 9-89 MAR 23 2018
130	Packaging	15 pcs		3/23/18	0.00	0.00	Packaging3-2		10/03/27 9-89 MAR 23 2018
140	QC21-SA	15 Ea		3/23/18	0.00	0.00	QC21		chm 18/03/27 9-89 MAR 23 2018

Part Op 100 - Issue P/O: _____ a) Description: Alluminum round billet b) Ø3.500" x 12.500" long c) Tolerance on all
Descriptions: dimensions are +0.030"/-0.000" d) Material: 7075-T7351 (QQ-A-225/9) Material certification required
110 - Ensure material certification is attached
130 - LOCATION: MAT043

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003P	Round Alum Billet	15 pcs (1 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6103-003P	15	0	0

Part Specifications

Specifications could not be found.

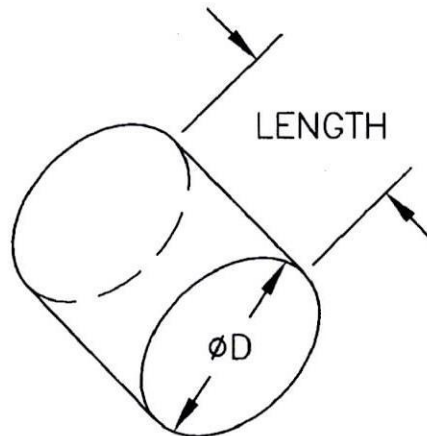
Plex 3/13/18 11:29 AM dart.lavoie.chantal



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 06103-003P
 DATE: MAR 23 2018

PO / BATCH NO.: 039292/5054516

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 22 PCS
 QUANTITY INSPECTED: 22 PCS
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 3.500
 THICKNESS RECEIVED: 3.500
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	Y (N)	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	Y (N)	
CORRECT MATERIAL PER M-DRAWING	Y (N)	QQ-A-22579
CORRECT THICKNESS	Y (N)	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	Y (N)	Heat # MA20171523
CORRECT MATERIAL IDENTIFICATION	Y (N)	
CORRECT M# ON THE MATERIAL	Y (N)	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 11</u> DATE: <u>9-89 MAR 23 2018</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 1

Shipment No:3548088

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 22-MAR-18	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 3548088-2	

Shipment Details			Final Destination Branch - TOR				
Order No	Line No	Item No	Description				
5081714	1	8808.MO	3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS-QQ-A-225/9				
Purchase Order No		Part Number	Ordered Qty		Invoice Qty		
39292		YOUR ITEM NUMBER: D6103-003	22.00 PCS		22.00 PCS		
Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No.	Mill/Source	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
121699722	ARCONIC INC			22			266.7582

We hereby certify the material covered by this certification conforms in accordance with the applicable specifications and has been found to meet the applicable requirements for the material, including any specifications for a part of the description. Test reports are on file subject to examination. All claims for defective material are subject to examination by A.M. Castle & Co. within 90 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative

Date: MAR 22 2018

Name

Certified Inspection Report

10/02/17
07:20:05

Arconic Inc.
ARCONIC FORGINGS AND EXTRUSIONS
45 County Route 42, Massena, NY 13662



Customer Castle A M & Co	Customer P.O. No. 442171	Customer Part No. (8808)	Arconic Order No. MMC-C4469-001	Govt. Contract No.
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Ship To **Castle A M & Co**
3800 Enterprise Drive
Janesville, WI 53548

We hereby certify that the material covered in this report has been inspected in accordance with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, or as previously agreed in with customer and that samples representative of the material met the composition limits and have the mechanical properties shown on the face of this sheet. Manufactured under a quality management system registered to ISO/AS9100. Melled and manufactured in the USA.

Joseph M. Vierno
Joseph M. Vierno, Quality Manager

Date Shipped 09/30/17	Weight Shipped 1,972 lbs	Product CFRB-CF ROD	Specific Length BOL 000165182
Alloy - Temper 7075-T7351	Size 3.50000 IN	Shape DIA	Config 12 FT
			QRR

Specifications:

AMS4124E
ASTMB211-12E1
Material conforms to T73 reqmts
Minimum mechanical properties to apply:
68 KSI Tensile Strength
56 KSI Yield Strength
10% Elongation
QD-A-2259E (Except Size)
AMS-QQ-A-225/9A (Except Size)
AMC A97075-11 R15

TEST REQUIREMENTS		Test	Test	Test	Test	Test	Test	Test	Test	Test
		U.T.S.	T.Y.S.	%Elong	Cond					
Max:			57.8							
Min:		68.0	56.0	10.0	38.0					

Test Results		Test	Test	Test	Test	Test	Test	Test	Test	Test
Lot / Work Order		U.T.S.	T.Y.S.	%Elong	Cond					
MA20171523										
Max:		73.7	63.2	14.0	41.2					
Min:		73.7	63.2	14.0	41.2					

TEST ABBREVIATIONS

U.T.S. Ultimate Tensile Strength KSI
Cond Conductivity % IACS

T.Y.S. Tensile Yield Strength KSI .2% offset

%Elong Elongation % In 2"

Aluminum Association Chemical Composition Limits (In Weight %)

		%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%Others	%Others	%AL
ALLOY	MAX	0.40	0.50	2.0	0.30	2.9	0.28	5.1	0.20	0.05	0.15	Rem
7075	MIN			1.2		2.1	0.18	5.1		Each	Total	

Actual Started Chemistry

LOT/WORK ORDER		%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%OE	%OT	%AL
MA20171523										LT 0.05	LT 0.15	Rem
MAX		0.05	0.13	1.6	0.00	2.5	0.19	5.8	0.02			
MIN		0.05	0.13	1.6	0.00	2.5	0.19	5.8	0.02			

Certified Inspection Report

10/02/17
07:20:05

Arconic Inc.
ARCONIC FORGINGS AND EXTRUSIONS
45 County Route 42, Massena, NY 13662



Customer Castle A M & Co	Customer P.O. No. 442171	Customer Part No. (8808)	Arconic Order No. MMC-C4469-001	Govt. Contract No.
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NOTES:

Ingot Source: Lafayette
Material compliant with DFARS 252.225-7001 (Buy American Act)
Mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product.
This alloy meets the requirements of EU 2011/65/EC (RoHS) and EU 2000/53/EC for lead, mercury, cadmium and hexavalent chromium.